

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020515**Date Inspected:** 12-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Sha Zi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #16

Weld joint 010, 011 Located on Bottom plate to stiffener, BP3095-001. Welder is identified as 068858. ZPMC Quality Control Inspector (QC) is identified as Gao Xing Hai. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Bay #19

During a random observation this QA inspector observed the following components for the Orthotropic Bridge Girder (OBG) in Bay 19;

Suspender Bracket SB 106W, SB 108E

Bike path BK005A-002

This QA observed that ZPMC was not performing any work on the above mentioned components during the time, this QA inspectors was present.

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Bay #14

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW)

Weld joint 400, Located on Lift 14W, Deck panel to Diaphragm DP3175-001. Welder is identified as 048433. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB.

Weld joint 335, 336, Located on Lift 14W, Deck panel to Diaphragm DP3176-001. Welder is identified as 048696. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB

Weld joint 246, 247, Located on Lift 14W, Deck panel to Diaphragm DP3177-001. Welder is identified as 203781. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133-ESAB

Weld joint 400, Located on Lift 14E, Anchor plate to Floor beam in P.P 127 mtr., SEG3019L. Welder is identified as 067520. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB.

Shielded Metal Arc Welding (SMAW):

Weld joint 001, Located on Deck panel to diaphragm, SEG3009. Welder is identified as 067571. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded by QC appeared to comply with the WPS-B-P-2211-B-U2-FCM-1.

Weld joint 021, Located on Deck panel to Deck panel, DP3173-001. Welder is identified as 037779. ZPMC Quality Control Inspector (QC) is identified as Qiu Wen. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-TC-U4B-FCM-1.

Submerged Arc Welding (SAW):

Weld joint 001, Located on Deck panel to Deck panel in Lift 13BE, SEG 3009 -001. Welder is identified as 215993. ZPMC Quality Control Inspector (QC) is identified as Xie Ming Feng. The welding variables recorded

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by QC appeared to comply with the WPS-B-T-2221-B-U2C-S-2.

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar, Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
